



Rolls-Royce

**Rolls-Royce Corporation
M250-C20R**

**COMMERCIAL SERVICE
LETTER
(CSL)**

**Technical Publications
Index**

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4001	M250 - Authorized Maintenance Center (AMC's), Publications, Rolls-Royce Telephone Contacts, Warranty, Training, and Unapproved Parts	Reissue 03-31-97	11	06-11-18
4002	Allison 250-C20R Series Engine Designations and Conversion Bulletin Information	04-01-87	2	08-01-91
4003	Warning Tags Attached To Fuel, Oil Air Tubes, Fittings and Associated Components On 250 Series Engines	09-10-87	2	09-26-00
4004	Guidelines For Operation Of "On Condition" Modules	04-01-88		
4005	Longer Life Ignitor Plugs	08-20-87	3	10-01-96
4006	Use Of Unapproved Parts, Engines, Major Modules, or Piece Parts That May Have Been in Long Term Storage In Rolls-Royce Commercial Engines	07-10-75	7	02-12-02
4007	Alert Document Compliance	01-31-87	3	10-01-96
4008	Publication Authorization Procedures	11-03-86	5	11-01-96
4009	Return Of Parts For Field Investigation At Allison Or Allison Authorized Maintenance Centers (AMC)	04-20-86	2	10-01-96
4010	Commercial Engine Bulletin Classification	06-16-86	4	06-19-19
4011	Field Vibration Test Procedure	10-17-86	10	06-19-19
4012	Chafe Wrapping Of Stainless Steel Tube Assemblies	05-01-88		
4013	Model 250 Fuel System-Operation and Maintenance Guidelines	05-11-79	2	11-01-88
A-4014	Operational Warning-Height Velocity Diagram (Not a Restriction Nor a Limitation)	Cancelled 07-18-06		
4015	Cancelled Prior to Publication			
4016	Serial Number Effectivity, Allison Commercial Engine Bulletins	05-01-88		
4017	Model 250 Series Engine Identification	Cancelled 04-07-08		
4018	Contamination Removal (Water Rinse) Instructions <u>Using Water Only</u>	06-23-86	11	12-20-19
4019	Commercial Engine Bulletin Incorporation Philosophy	04-30-88		
4020	Installation of New Gas Producer Tiebolt Nut, P/N 23039751	Cancelled		
4021	Rolls-Royce Customer Training	08-01-88	21	05-27-15

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4022	Cancelled Prior to Publication			
4023	Translation of Allison Technical Publications into Foreign Languages	11-01-88		
4024	Use of Eastern European, United Kingdom, and Peoples Republic of China Specification Fuels in Rolls-Royce M250 Engines	04-01-89	7	03-26-14
4025	Guidelines for Operation of Manually Activated Fuzz Burning Engine Chip Detectors	11-01-88		
4026	Heavy Maintenance Inspection Compliance - Optional Gas Producer Turbine Replacement	Cancelled		
A-4027	Use of Salvaged or Scrapped Parts in Allison Model 250/225 Engines	12-01-88	1	08-15-91
4028	Cancelled Prior to Publication			
4029	Cancelled Prior to Publication			
4030	Seal Shelf Life (Age Control)	05-01-89	1	08-22-11
4031	250-C20R Series Operational Characteristics	04-01-89	1	06-20-92
4032	Operation of Bendix Fuel Controls and Power Turbine Governors Exposed to Fire or Severe Overtemperature	04-14-89		
4033	Cancelled Prior to Publication			
4034	Purolator/Facet External Scavenge Oil Filter Inspection	02-01-90	3	05-03-10
4035	Heavy Maintenance Inspection (HMI) Compliance Option A	Cancelled 06-21-16		
A-4036	Maintenance Warning - External Lines	11-15-90	2	07-08-19
4037	Allison Auto Reignition Control System	12-31-89		
4038	Noisy 250 Series Fuel Pumps	11-26-75	4	06-08-04
4039	Model 250 Reporting	02-20-75	8	02-07-11
4040	Model 250 Logbook Changes	11-15-94		
4041	N ₂ /N _R Speed Setting	03-15-92		
4042	Model 250 Engine Designations and Applications	11-30-91	5	07-13-15
4043	"B" Nut Warning Placard	Cancelled		
4046	Special Instructions for Engines Operated in Volcanic Ash	06-02-80	5	01-05-07

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4048	Lubrication System Troubleshooting	06-07-79	7	09-14-09
4049	Model 250 Engine Mean Time Between Removal Experience and Recommendations on Use of Overhauled First-Stage Turbine Nozzles	01-31-91	2	05-30-94
4050	Optimized Start Technique for Allison 250-C20 Series and C20R Series Engines	12-15-92		
4051	Spectrographic Oil Analysis Programs (SOAP) Versus Magnetic Drain Plug Lights -- Safety Warning	09-30-80	3	11-01-96
4052	Release of New Material Bleed Valve Data Tag	04-30-92		
4053	Unapproved Hot Engine Cool Down Procedure	03-01-93	1	11-13-01
4054	Recommendations in Conjunction with Engine Oil Change	04-30-93	1	04-15-98
4055	Operation and Maintenance Manual Publications Concerning Magnetic Chip Detector Guidelines	04-30-93		
4056	Authorized Allison Repair/Overhaul Facilities for the Allison Model 250 Engine	Cancelled		
4058	Premature Engine Removals Due to Metal Generation from the 2 1/2 Bearing	04-30-93		
4059	Change in Commercial Engine Bulletin Index Format	06-15-93		
A-4062	Inspection, Rework, and Overhaul of Parts Manufactured by Anyone Other Than Allison and/or Allison Approved Vendors and Suppliers	02-15-94	1	11-30-94
4063	Handling of Fluorocarbon Elastomer Preformed Packings and/or Seals	02-01-95		
4064	TBO Extension Program, 250 Series Engines	09-14-84	3	04-30-96
4065	Allison Model 250 Engine Customer Support and Service Parts Telephone Numbers	Cancelled 02-01-02		
4066	Model 250 Power By The Hour®/Fleet Hour Agreement Program	09-30-94	6	Cancelled 02-22-08
4067	Use of Rolls-Royce Military Surplus Parts in Commercial Engines	01-27-95	5 Reissue	04-23-02
4068	Troubleshooting Guide for Bendix Fuel Systems Used on Helicopters	06-30-97		
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4072	Model 250 Publications Procurement Policy	02-15-96	3	03-03-08
4073	Letterhead, Model 250 Commercial Engine Bulletins, Commercial Service Letters and Installation Bulletins	11-15-95		
4074	Manufacturing Origin Request Procedure	02-20-96	3	07-23-04
4075	Rolls-Royce Part or Assembly Modification	07-31-96	2	05-22-02
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4077	No-Go Gages for Spline Inspection	11-15-97	Cancelled	02-10-14
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4080	Return of Model 250 Field Parts for Investigation at Rolls-Royce	06-30-97	4	04-06-15
4082	Commercial Engine Bulletin, CECO Fuel Pump Spline Inspection	09-02-97		
4083	Use of High Thermal Stability (HTS) or Third Generation Oils	09-15-97	2	02-13-12
4084	Hot Corrosion - Sulfidation	02-10-00	1	05-25-04
4085	Inconel Bellows Incorporation in All 250 AlliedSignal (Bendix) Fuel Controls	02-27-98		
4086	Returning of CEB Compliance Sheets with 250 Engine Module to be Repaired	12-01-85	1	08-07-98
4088	OEM Engine Warranty	04-15-99	1	07-08-16
A-4092	Model 250 Engine Cautions For Changes In Engine Noise	09-15-99		
4093	Alternate Consumable Materials List	04-19-00	3	09-17-12
4094	Rolls-Royce Model 250/Aviall Parts And Technical Publications Distribution	Cancelled 01-25-02		
4095	Manufacturing Tooling Marks On Tubing Assemblies	04-11-00	1	04-27-09
4096	Model 250 Lip Seals	09-07-00	3	05-16-14
4097	Engine - New Publications Prices	08-01-00	1 Reissue	08-24-00
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A-4100	Honeywell Extension Of Inconel Bellows Special Pricing	12-20-00		
4101	Second Stage Nozzle Special Pricing Policy	Cancelled 03-15-10		
4102	Black Oxide Removed From Specified Gears	04-05-01	1	04-08-03
4103	Use Of AN503-8-8 Screws In Honeywell Products	04-25-01		
4104	C20R Series Compressor Front Support Special Pricing Policy	08-01-01	1	02-13-02
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4108	Rolls-Royce Model 250 Engine Customer Support And Service Telephone Numbers	Cancelled 03-20-08		
4109	MTU Manufactured Parts	01-08-02	1	02-02-17
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4112	Gearbox Bore Alignment Check	05-02-03	1	08-27-04
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4121	Benefits of an External Scavenge Oil Filter	08-01-82	2	07-28-05
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4128	Quick Disconnect Magnetic Plug Installation	02-07-07	1	11-17-15
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A-4153	Enhanced Awareness of Loose or Broken Split Line Bolts/ Studs	02-09-18		
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